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D4379-5**Job Sheet 201956****Part No:** D4379-5**Job Qty:** 400 pcs**Part Name:** Wearplate Cup**Part Weight:** 0 lbs**Job Created:** 10/17/19**Due Date:** 11/8/19**Type:** SOLD**Status:** New**Priority:** Medium**Job Tracking No:****Created By:** Marie Lajeunesse**Description:****Note:** DWG REV D SHEET 3 IPP REV:A NEW ISSUE 14-04-01 JLM VERIFIEWD BY:DD**Ship Via:****Bill of Materials****Job Routing**

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
100	Doosan - 1	400 pcs	11/8/19	11/8/19	1.00	33.33	Doosan - 1	
120	QC 8	400 pcs	11/8/19	11/8/19	0.00	0.00	QC 8 - 12	
							QC 8 - 14	
							QC 8 - 17	
							QC 8 - 20	
							QC 8 - 25	
							QC 8 - 3	
							QC 8 - 32	
							QC 8 - 33	
							QC 8 - 35	
							QC 8 - 39	
							QC 8 - 4	
							QC 8 - 44	
							QC 8 - 45	
							QC 8 - 49	
							QC 8 - 58	
							QC 8 - 8	
							QC 8 - 9	
							QC 8 - 68	
							QC 8 - 67	
							QC 8 - 1 (A)	
							QC 8 - 47	
							QC 8 - 40	
							QC 8 - 52	
							QC 8 - 23	
							QC 8 - 57	
							QC 8 - 76	
							QC 8 - 61	
130	Packaging 3-1 - Stock - B4B	400 pcs	11/8/19	11/8/19	0.00	0.00	Packaging 3 - 1 - B4B	
							Packaging 3 - 2 - B4B	
							Packaging 3 - 3 - B4B	



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Container No: S230363**Part:** D4379-5**Job No:** 201956**Serial No/Batch:** S230363**Revision:****Inspector:****Exp Date:****Instructions:** Various STC's**Date:** 11/09/19

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					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	2
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - SA	400 pcs	11/8/19	0.00	0.00	QC 21 - SA - 21	NOV 11 2019
					QC 21 - SA - 70	
					QC 21 - SA - 53	

Part Op 100 - Doosan Lathe - turn as per Dwg and folio FB300
 Descriptions: 120 - QC8- Inspect parts - second check
 130 - Identify as per dwg & Stock LOCATION: WA001-15
 140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304R1.000	304 Round Bar 1.00	19.2000 ft (.048 ea)	100-Doosan - 1	5190202

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M304R1.000	19	8	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearplate Cup	0.875Inches + 0.000 - 0.005	0.875 0.870	Diameter	
2	Wearplate Cup	0.266Inches + 0.006 - 0.001	0.272 0.265	Diameter	
3	Wearplate Cup	0.466Inches ± 0.010	0.476 0.456		
4	Wearplate Cup	0.353Inches ± 0.010	0.363 0.343		
5	Wearplate Cup	0.031Inches ± 0.010	0.041 0.021		
6	Wearplate Cup	45.000Degrees ± 0.500	45.500 44.500	Angle	
7	Wearplate Cup	0.200Inches ± 0.010	0.210 0.190		
8	Wearplate Cup	0.507Inches ± 0.010	0.517 0.497		

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Entered: _____ Date: _____ **WORK ORDER NON-CONFORMANCE / ROUTE UPDATE**

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐ ☐ ☐
Scrap ☐ ☐ ☐
Use-as-is ☐ ☐ ☐

DEPARTMENT/PROCESS

Cross tube ☐ ☐ ☐
Small Fab ☐ ☐ ☐
Finishing ☐ ☐ ☐
Skid-tube ☐ ☐ ☐
Machining ☐ ☐ ☐
Large Fab ☐ ☐ ☐

Eng. (Non-AW) ☐ ☐ ☐
Prod. Eng. Coord. ☐ ☐ ☐
Rec/Store/Packaging ☐ ☐ ☐
Engineering ☐ ☐ ☐
Water Jet ☐ ☐ ☐
Supplier ☐ ☐ ☐
Quality ☐ ☐ ☐

Date: _____ Sequence #: _____

QTY Affected: _____

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐ ☐ ☐
Manufacturing Process ☐ ☐ ☐
Equip/Tooling ☐ ☐ ☐
Handling/Preservation ☐ ☐ ☐
Material ☐ ☐ ☐
Product Improvement ☐ ☐ ☐
Process Improvement ☐ ☐ ☐
Human Factors ☐ ☐ ☐

FAULT CATEGORY

Pressure/Forced ☐ ☐ ☐
Bending ☐ ☐ ☐
Crushing ☐ ☐ ☐
Cracks ☐ ☐ ☐
Crimp/Kink/Ripple/Wave/Twist ☐ ☐ ☐
Marks/Chatter ☐ ☐ ☐
Mislabeled ☐ ☐ ☐
Contamination ☐ ☐ ☐
Misaligned/off center ☐ ☐ ☐
BOM/Route ☐ ☐ ☐
Broken/Damage/Defect ☐ ☐ ☐
Incomplete/Unclear Instructions ☐ ☐ ☐
Drill Holes ☐ ☐ ☐
Fit/Function ☐ ☐ ☐

Power Loss/Surge ☐ ☐ ☐
Folio/Program ☐ ☐ ☐
Grain Direction ☐ ☐ ☐
Weld ☐ ☐ ☐
Wrong Stock Pulled ☐ ☐ ☐
Out of Sequence ☐ ☐ ☐
Off-set/Set-up ☐ ☐ ☐
Positioned Wrong ☐ ☐ ☐
Outside Tolerance ☐ ☐ ☐
Drawing ☐ ☐ ☐
Finish ☐ ☐ ☐
Part Lost/Missing ☐ ☐ ☐
Misread ☐ ☐ ☐

Other/Details: _____